

Tuesday, June 27, 2017 1:13:28 PM

Item ID: D350-607-545

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Stop *NS2*

Start Date: 6/27/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: DAS Date: JUN 28 2017 Tooling: _____ Date: _____
 QC: 9-88 Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D350-607-3	E	

100	Document Control	6	0.00		
100	DOCUMENT CONTROL	9.89			
DC	Memo		0.00		
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-545 CHG008				

110	Pick Kit	0.00	
110			JUL 26 2017 <i>[Signature]</i> DAS 6
Packaging	Memo	0.00	<u> </u> <u> </u> <u> </u> 9-89
Packaging			

115	QC5- Inspect part completeness to step on W/O	0.00	28 AUG 01 2017
115			
QC	Memo	0.02	
Quality Control	***Inspect labe lon lid***		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 163452

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163452

Page 2

Item ID: D350-607-545

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									
130	Identify as per dwg & Stock Location: <u>Eg</u>	0.00							
130									
Packaging	Memo	0.01							
Packaging	Package as per PPPD350-607-545								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
28
9-89

AUG 01 2017

DAS
28
9-89

AUG 01 2017

DAS
21
9-89

AUG 01 2017

DAS
21
9-89

AUG 01 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B
10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:C 11.02.09
add to install label DD verf by:EC IPP REV:D 12.03.06 AS PER
ECN12-535 DD VERF:EC IPP REV:E 12.07.24 AS PER ECN 12-610
DD VERF:EC IPP REV:F 13.08.21 CHG005 / ECN 13-624 DD
VERF:JLM IPP REV:G 14.06.09 AS PER ECN14-572 DD VERF:JLM
IPP Rev.H 17.06.08 As per IIN Rev.E DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4085-3 *D4085-3* Placard		Manufactured	No			110	Each	6.0000	1 **	1			DAS 6 9-89 JUL 26 2017
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST074			6		B162929	1			
				162761			6		6/16/2018				
D4086-220 *D4086-220* Placard, Max Load		Manufactured	No			110	Each	15.0000	1 **	1			DAS 6 9-89 JUL 26 2017
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST078			15						
				162778			15		6/15/2018	1			
D4917-320 *D4917-320* Placard, Max Load		Manufactured	No			110	Each	7.0000	1 **	1			DAS 6 9-89 JUL 26 2017
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST137			7						
				160143			7		5/4/2018	1			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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703 21 010								Lead hand / Supervisor Approval Verification																																																															
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Picklist Print

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Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

D350-607-511

Manufactured No

110

Each

5.0000

**

1

D350-607-511

AS350/AS355 Quick Release Basket/Long Cargo Tube Mounting Provisions, Fits LH/RH

DAS
28
9-89

Location

FG128

161839

162816

Loc Qty

5

1

4

Loc Code

B163874

1

D2690-6

Manufactured No

110

Each

41.0000

**

1

D2690-6

Lanyard

DAS
28
9-89

Location

ST009

159568

162919

Loc Qty

41

23

18

Loc Code

1

D3912-041

Manufactured No

110

Each

7.0000

**

1

D3912-041

Eyebolt Receiver Assembly

DAS
28
9-89

Location

ST055

161824

161825

Loc Qty

7

3

4

Loc Code

1

D4032-041

Manufactured No

110

Each

0.0000

**

1

D4032-041

Short Basket Assembly (350)

DAS
28
9-89

163533

JUL 26 2017

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

D4151-041

Manufactured No

110

Each

16.0000

1

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST088

8

159508

8

ST090A

8

159524

4

161846

4

D4151-043

Manufactured No

110

Each

17.0000

1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST088

5

159536

5

ST090A

12

159788

8

162019

4

D4150-041

Manufactured No

110

Each

15.0000

1

D4150-041

Attachment Arm Assembly

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST087

11

159036

1

159781

10

ST090A

4

161919

4

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Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐		
		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐		
NCR No. _____		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐		
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐		
Date :	Step #:	QTY Effective :							MRB (QS1042) Approval				
Description Work Order Deviation				Disposition									
												Completed By	
												Lead hand / Supervisor Approval Verification	
												QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐		
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐		
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐		
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐		
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐		
Past Expiry Date	☐	Manufacturing Process	☐										
Misidentified	☐	Past Due	☐	OTHER :									

Picklist Print

Tuesday, June 27, 2017 1:13:31 PM

Page 4

Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

110

Each

494.0000

**

6

AN4-13A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	20	
122808	20	
GA	68	
m134634	19	
m135470	49	
over003	350	
m137680	100	
<u>m137886</u>	250	
ST344	56	
m137544	56	

JUL 26 2017

AN4C15

Purchased

No

110

Each

45.0000

**

1

AN4C15

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER002	25	
M137736	25	
ST343	20	
<u>M137506</u>	20	

JUL 26 2017

AN310C4

Purchased

No

110

Each

58.0000

**

1

AN310C4

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST331	58	
M135895	1	
M137361	32	
<u>M137412</u>	25	

JUL 26 2017

Tuesday, June 27, 2017 1:13:31 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 5

Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased No

110 Each

28.0000

1 1

MS17984-C413

Quick Release Pin

DAS
28
9-89

Location

Loc Qty

Loc Code

ST315

28

m137478

25

m137587

3

**

DAS
6
9-89

JUL 26 2017

MS21042L4

Purchased No

110 Each

2,061.000

6 6

MS21042L4

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

51

m135058

51

OVER007

1400

m137402

400

m137680

1000

ST303

600

m137544

600

**

DAS
6
9-89

JUL 26 2017

MS24665-151

Purchased No

110 Each

107.0000

1 1

MS24665-151

Cotter Pin

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

47

m137391

47

**

DAS
6
9-89

JUL 26 2017

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER: ☐			

Picklist Print

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Page 6

Work Order ID: 163452

163452

Parent Item: D350-607-545

D350-607-545

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4L

Purchased

No

110

Each

214.0000

2 2

***NAS1515H4I ***

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

23

103691

3

m132189

20

ST260

103

m133483

103

ST260a

88

m134376

88

NAS1149F0432P

Purchased

No

110

Each

1,113.000

12 12

NAS1149F0432P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

1000

M137412

1000

ST262

113

M137361

113

NAS1149C0463R

Purchased

No

110

Each

357.0000

3 3

NAS1149C0463R

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

25

m127306

25

ST260a

200

m137736

200

ST266

132

m136263

132

DAS
6
9-89

JUL 26 2017

DAS
6
9-89

JUL 26 2017

DAS
6
9-89

JUL 26 2017

Tuesday, June 27, 2017 1:13:31 PM

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Page 6

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																				
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<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> <th colspan="4" style="text-align: left; padding: 5px;">FAULT CATEGORY</th> </tr> <tr> <td style="width:10%; padding: 5px;">Environment ☐</td> <td style="width:10%; padding: 5px;"></td> <td style="width:10%; padding: 5px;">No Re-verification ☐</td> <td style="width:10%; padding: 5px;"></td> <td style="width:10%; padding: 5px;">Pressure/Forced ☐</td> <td style="width:10%; padding: 5px;"></td> <td style="width:10%; padding: 5px;">Temperature/Cure ☐</td> <td style="width:10%; padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Design ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Operator ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Bending ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Set-up ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Doc/Data ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Offset/Setup ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Centre Not Concentric ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">BOM/Route ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Equip/Tooling ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Supplier ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Cracks ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Broken/Damage/Defect ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Handling/Pre ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Training ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Crimp/Kink/Ripple/Wave ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Inspection Incomplete/Unqualified ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Material ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Use for Testing ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Cuffs ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Contamination ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Internal Transport ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Poor Information ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Crushing ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Countersink ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Tribal Knowledge ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Rushing ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Heat Treat ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Cut Too Short ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">LOA ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Product Improvement ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Wave/Twist in Tube ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Instructions Incomplete/Unclear ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Substation ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Process Improvement ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Marks/Chatter ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Drill Holes ☐</td> <td style="padding: 5px;"></td> </tr> <tr> <td style="padding: 5px;">Past Expiry Date ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Manufacturing Process ☐</td> <td style="padding: 5px;"></td> <td colspan="4" rowspan="2" style="padding: 5px; vertical-align: top;">OTHER : _____</td> </tr> <tr> <td style="padding: 5px;">Misidentified ☐</td> <td style="padding: 5px;"></td> <td style="padding: 5px;">Past Due ☐</td> <td style="padding: 5px;"></td> </tr> </table>					Root Cause				FAULT CATEGORY				Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Design ☐		Operator ☐		Bending ☐		Set-up ☐		Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____				Misidentified ☐		Past Due ☐	
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Work Order ID 163452***163452***

Tuesday, June 27, 2017 1:13:28 PM

Item ID: D350-607-545

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Heavy Duty Lid

Start Date: 6/27/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1Approvals: Process Plan: _____ Date: JUN 28 2017 Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL	0.00							
DC	Memo								
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-545 CHG008								
110	Pick Kit	0.00							
110		0.00							
Packaging	Memo								
Packaging									
115	QC5- Inspect part completeness to step on W/O	0.00							
115		0.02							
QC	Memo								
Quality Control	***Inspect labe lon lid***								

DAS
5
9-89

JUL 25 2017

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
1	1	1	1	1	1	D4085-3	PLACARD, INSTRUCTIONS
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				1	1	D4713-1	SPACER
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
				1	1	MS3367-5-0	TIE WRAP
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER